

Date: Monday, 10/30/2006 4:15:13 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE		
Job Number	: 29230					
Estimate Number	: 10831					
P.O. Number	: N/A			Part Number	: D29321	
This Issue	: 10/30/2006 S.O. No. : N/A			Drawing Number	: D2932 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: B	
Previous Run	: 28937			Material	: N/A	
Written By	: <i>dk</i> 06/10/08			Due Date	: 11/30/2006	
Checked & Approved By	: <i>dk</i>			Qty:	8	
Comment	: Est: B 06.06.26 New DWG rev, (mpp 2069) EC			Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	7075-T7351 2X6.25X7.875	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length Batch No: <i>B25346</i>	<i>mk 06/11/08</i> 8
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 5-Deburr & TUMBLE	<i>mk 06/11/08</i> 8
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	<i>SA 06.11.19</i> 8
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	<i>mk 06/11/08</i> 8

WORK ORDER CHANGES

W/O:	DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/12/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/30/2006 4:15:13 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 29230

Part Number: D29321

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

E 06/12/20

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

9.m/sr.

06/12/19

⑧

7.0 POWDER COATING POWDER COATING



M102391

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-h/yl 06/12/20

⑧

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Ac/12/21 (8)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5473

Ac/12/21 (8)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



⑧

Comment: FINAL INSPECTION/W/O RELEASE

Ac/12/20

Job Completion



Ac/12/21

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	29230
Description: 206 Saddle, Outboard, Left side				Part Number:	D2932-1
Inspection Dwg: D2932 Rev. B				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.126	0.127	0.128	0.126		
B	0.100	0.140		0.128	0.126	0.123	0.123		
C	0.100	0.140		0.131	0.117	0.116	0.117		
D	0.210	0.230		0.218	0.222	0.218	0.218		
E	1.245	1.255		1.249	1.250	1.256	1.250		
F	1.245	1.255		1.249	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.499	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.576	1.576	1.576	1.576		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
L	0.312	0.317	DT8686	0.314	0.314	0.314	0.314		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		0.121	0.121	0.118	0.118		
O	0.540	0.560		0.542	0.551	0.550	0.550		
P	0.490	0.510		0.499	0.501	0.503	0.506		
Q	3.715	3.725		3.717	3.719	3.720	3.720		
R	2.470	2.510		2.495	2.492	2.497	2.493		
S	0.240	0.270		0.251	0.250	0.253	0.251		
T	0.100	0.180		0.131	0.137	0.138	0.140		
U	1.625	1.635		1.629	1.628	1.629	1.629		
V	1.362	1.372		1.368	1.366	1.367	1.367		
W	0.316	0.321	DT8690	0.320	0.320	0.320	0.320		
X	1.125	1.145		1.135	1.131	1.132	1.133		
Y	1.565	1.585		1.569	1.570	1.567	1.572		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	10ml	Audited by:	EP
Date:	06/11/08	Date:	06/12/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#

DART AEROSPACE LTD				Work Order:	29230
Description: 206 Saddle, Outboard, Left side				Part Number:	D2932-1
Inspection Dwg: D2932 Rev. B				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.126	0.125	0.125	0.125		
B	0.100	0.140		0.121	0.122	0.122	0.122		
C	0.100	0.140		0.112	0.112	0.116	0.115		
D	0.210	0.230		0.219	0.220	0.219	0.221		
E	1.245	1.255		1.250	1.250	1.250	1.251		
F	1.245	1.255		1.256	1.249	1.250	1.256		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.576	1.577	1.578	1.576		
J	2.495	2.505		2.500	2.499	2.500	2.500		
K	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
L	0.312	0.317	DT8686	0.319	0.314	0.314	0.314		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		0.119	0.119	0.118	0.118		
O	0.540	0.560		0.549	0.550	0.548	0.548		
P	0.490	0.510		0.503	0.501	0.505	0.505		
Q	3.715	3.725		3.718	3.716	3.718	3.718		
R	2.470	2.510		2.495	2.494	2.493	2.493		
S	0.240	0.270		0.250	0.250	0.250	0.248		
T	0.100	0.180		0.135	0.145	0.138	0.136		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.367	1.366	1.367	1.366		
W	0.316	0.321	DT8690	0.320	0.320	0.320	0.320		
X	1.125	1.145		1.132	1.133	1.133	1.133		
Y	1.565	1.585		1.571	1.572	1.571	1.572		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: *-h2L*
Date: 04/11/08

Audited by: *CP*
Date: 06/12/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF <i>FF</i>	<i>FF</i>

